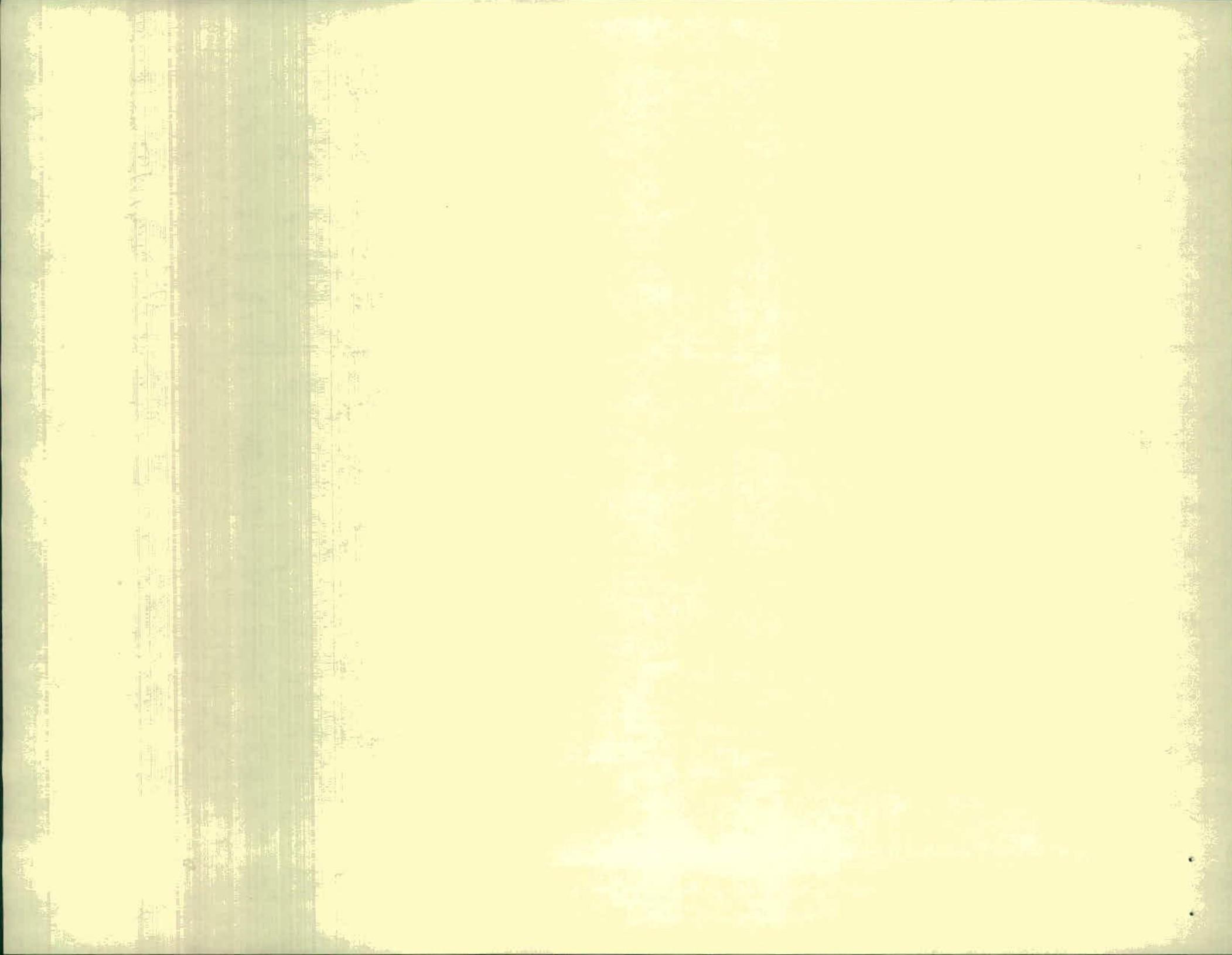


Date: Monday, 08/09/2008 2:50:47 PM
User: Julie Lecocq

Process Sheet

SP/IT -

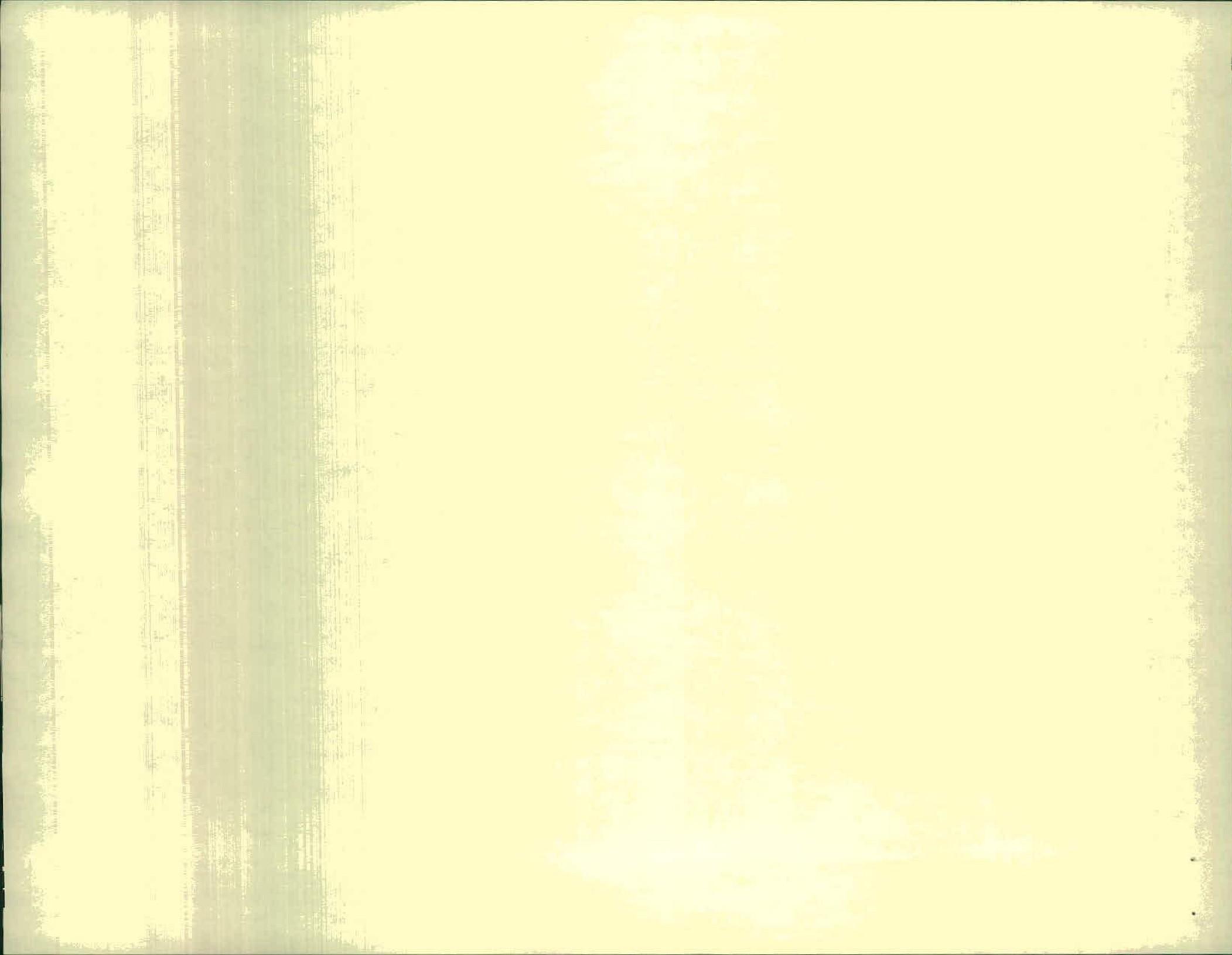
Customer : CU-DAR001 Dart Helicopters Services Job Number : 41890 Estimate Number : 11175 P.O. Number : This Issue : 08/09/2008 S.O. No. : Prsht Rev. : NC First Issue : / / Type : MACHINED PARTS Previous Run : 39717 Written By : Checked & Approved By : <u>JUL089108</u> Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM EstRev:B Now on Doosan Lathe 08-06-05 JLM Verified By:EC		Drawing Name : TUBE Part Number : D22825 Drawing Number : D2282 REV E Project Number : N/A Drawing Revision : E Material : Due Date : 30/10/2008 Qty: <u>100</u> Um: Each
Additional Product		
Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M304R0750 	304 SS Roundbar .750
Comment: Qty.: 0.1891 f(s)/Unit Total : 18.9063 f(s) Material: AISI 304 Stainless Steel 0.750(M304R0.750) Batch <u>M10942</u>		J.F. 08/10/23 (58)
2.0	DOOSAN LATHE 	DOOSAN LATHE
Comment: DOOSAN LATHE 1-Turn as per Dwg D2282 and Foto FA189 2-Deburr		J.F. 08/10/23 (58)
3.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		J.F. 08/10/23 (58)
4.0	QC8 	SECOND CHECK
Comment: SECOND CHECK		08/10/24 (58)
5.0	PACKAGING 1 	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: (MISC)		SL 08/10/27



Date: Monday, 08/09/2008 2:50:47 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: TUBE	
Job Number: 41890		Part Number: D22825	
Job Number:			
Seq. #:	Machine Or Operation:	Description	
6.0	QC21 	FINAL INSPECTION/W/O RELEASE	 08/10/27 JF
Comment: FINAL INSPECTION/W/O RELEASE			
Job Completion			MF 08-10-27



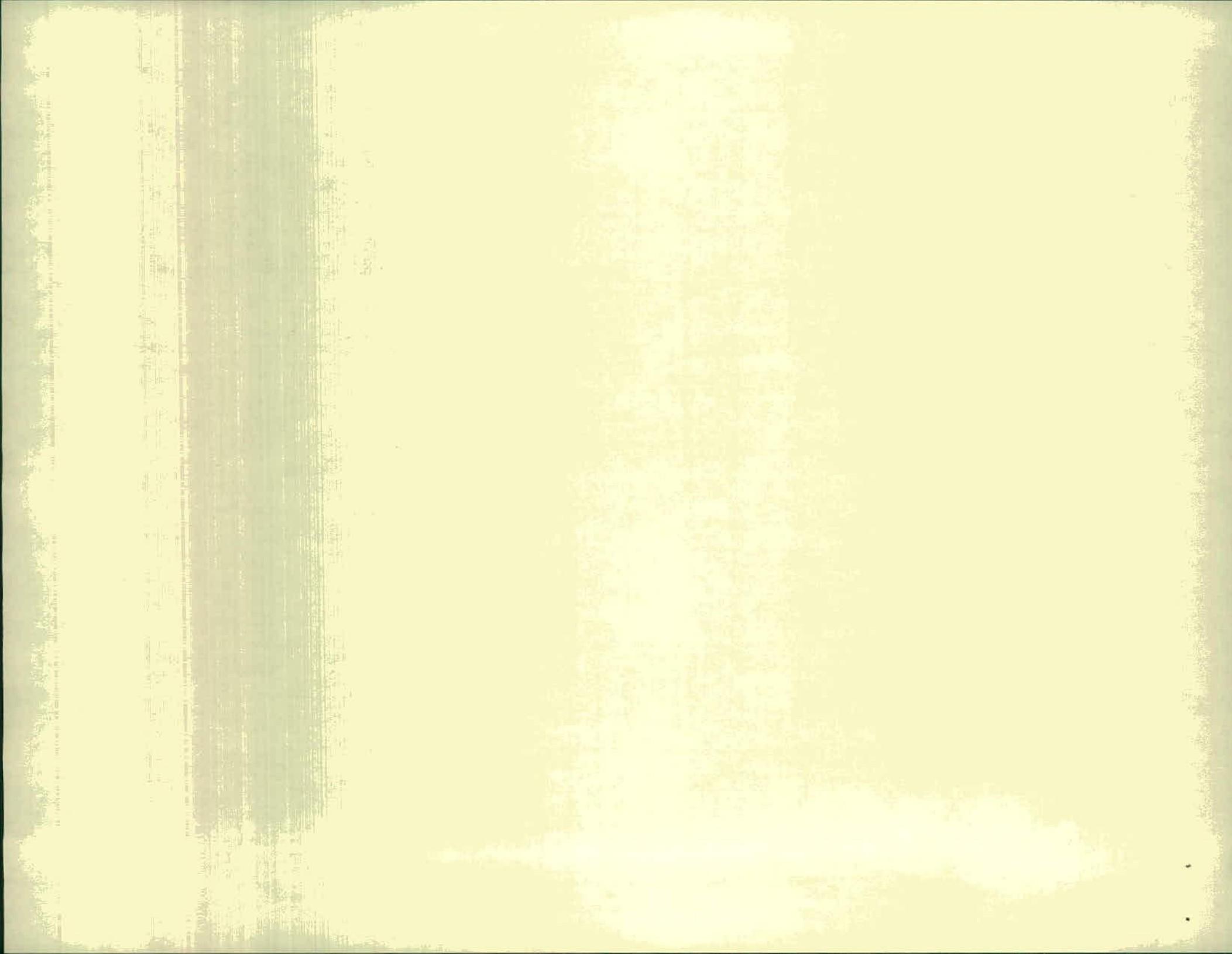
DART AEROSPACE LTD		Work Order:	41890
Description: Handle Tube		Part Number:	D2282-5
Inspection Dwg: D2282	Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

Measured by:	J.F.	Audited by:		Prototype Approval:	N/A
Date:	08/10/15	Date:	08/10/24	Date:	N/A

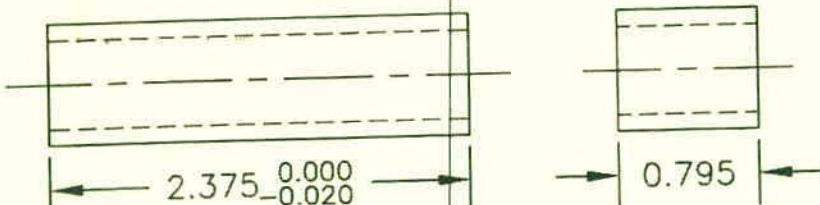
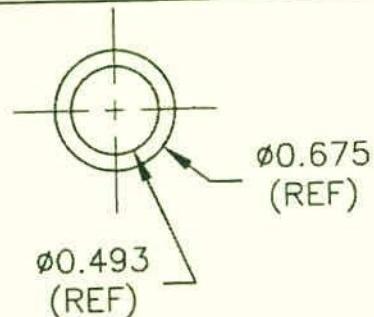
Rev	Date	Change		Revised by	Approved
A	03.11.11	New Issue	P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed		KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E		KJ/JLM	
D	07.11.26	Ø0.700 dimension added		KJ/EC/DD	BB



DART

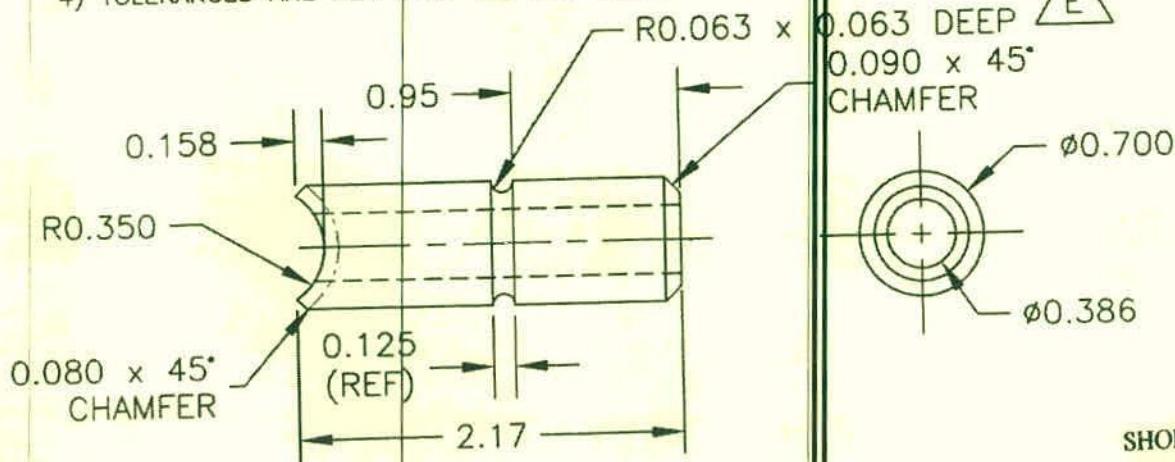
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]
 BS/09/16

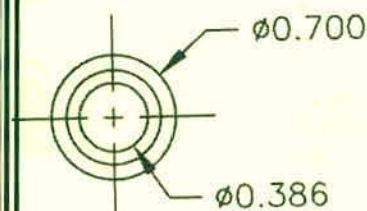
**D2282-3****D2282-7**

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5**

E
0.063 DEEP
0.090 x 45°
CHAMFER

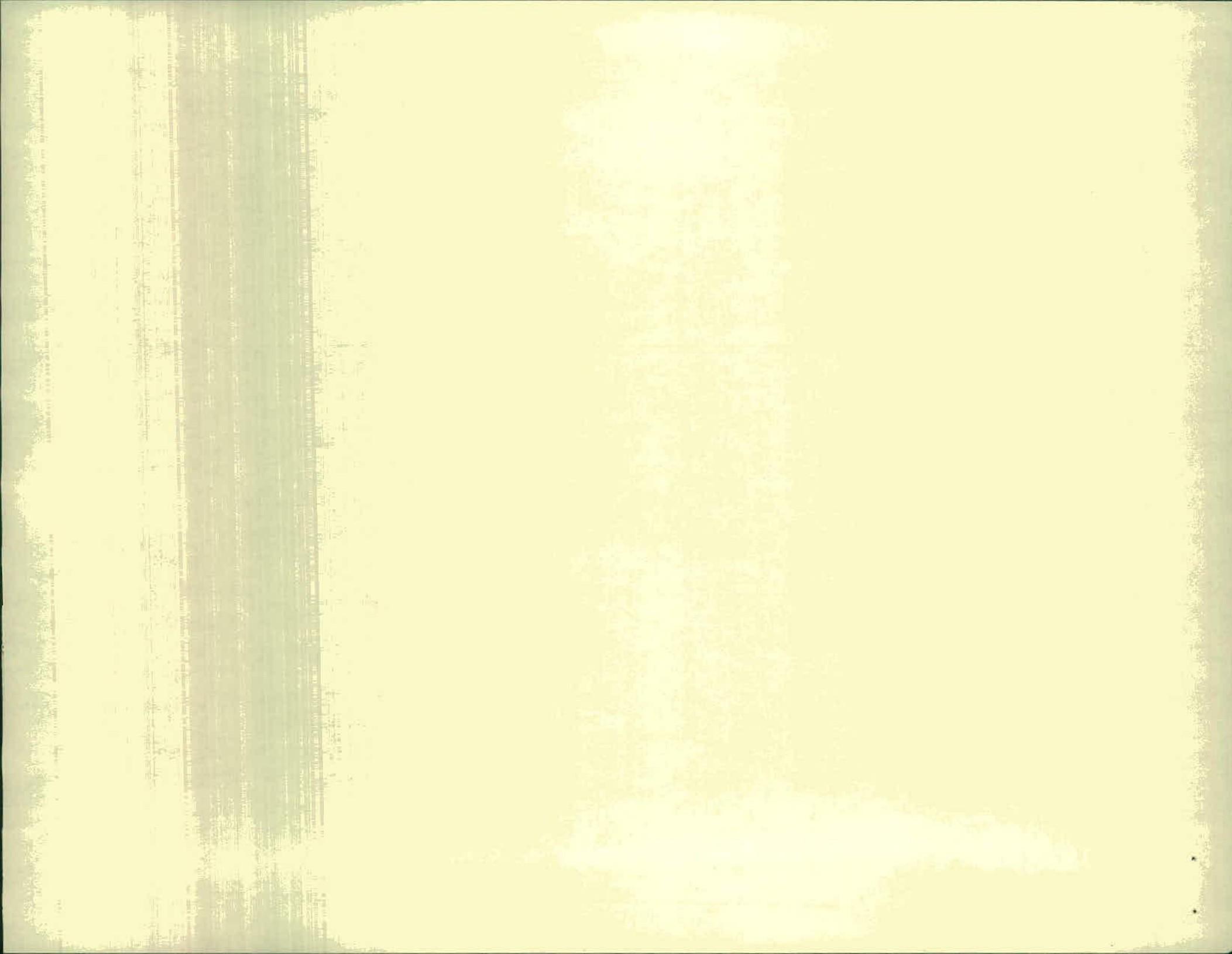
**D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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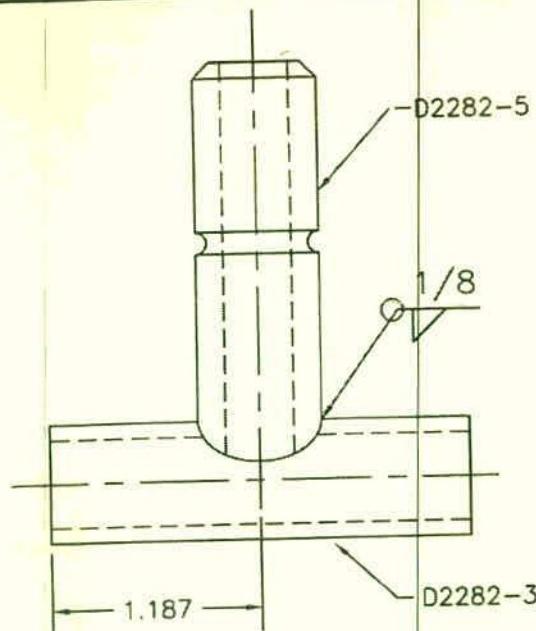
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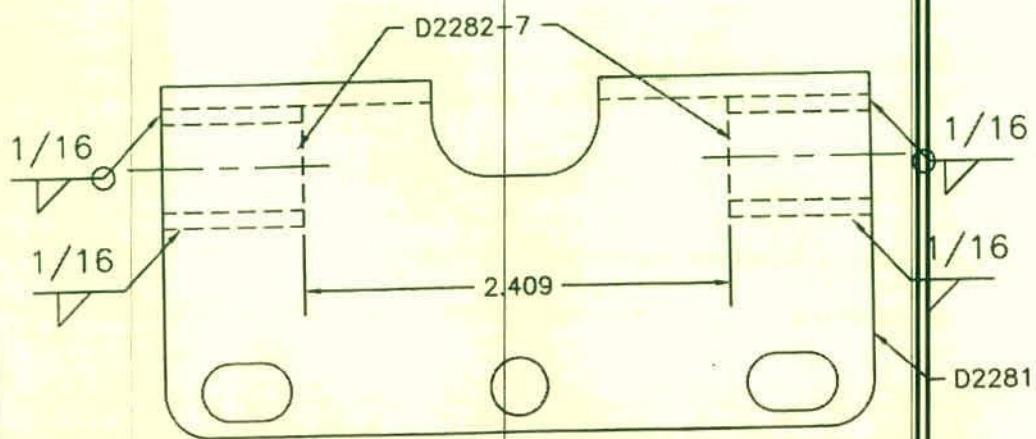
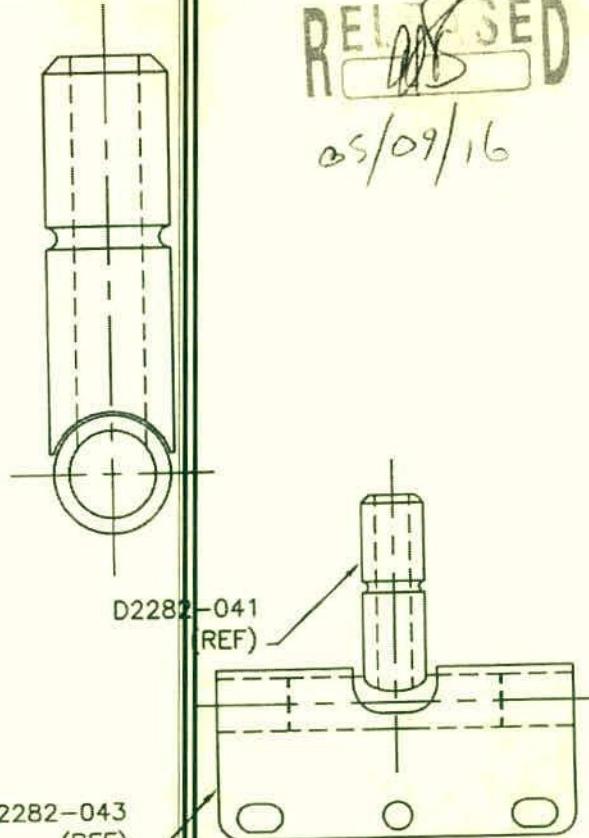


DART

DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES	SCALE 1:1	



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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